

Work Order ID 60018

Tuesday, June 22, 2010 3:23:52 PM



Page 1

Item ID: D4043-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-6-22 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4043

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D4043
2- Deburr and remove identification markings

SAD

10-06-23

①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/23

②

120

Identify as per dwg & Stock Location: 5. cell

0.00



Packaging

Memo

0.00

Packaging

③ PD 10-06-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60018

Tuesday, June 22, 2010 3:23:52 PM



Page 2

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Setup Start



Revision ID:

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Item Name: Rib

Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 JF

pl 10-6-24
①

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

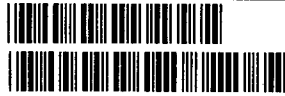
Tuesday, June 22, 2010 3:23:56 PM

Page 1

Work Order ID: 60018

Parent Item: D4043-3

Parent Item Name: Rib



Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TS0.500W.049

Purchased

No

100

f

155.2554

2.1392

2.251789



Square Tubing



SAO 10-06-23

Location

Loc Qty

Loc Code

MAT

148.1591158

114004

0

114426

9.2647

114807

138.894416

MAT018

4.4738

114004

0.5

114161

3.9738

WA

2.62251

114724

2.62251

2.251789

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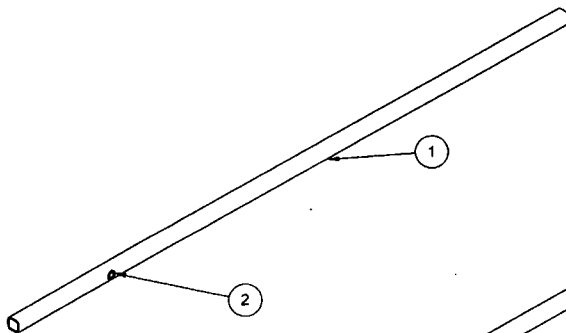
NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------|
| | X | D4043-041 | RIB ASSEMBLY |
| 1 | 1 | D4043-1 | RIB |
| 2 | 1 | D4043-9 | BUSHING |

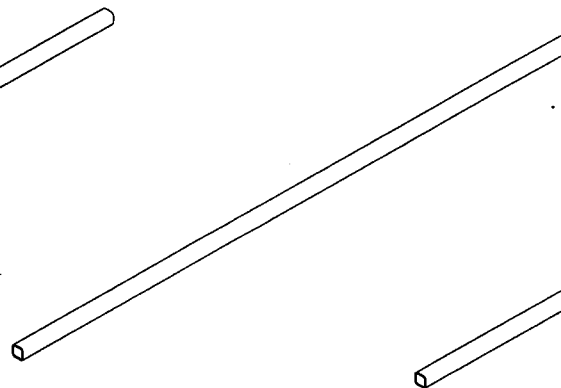
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 60018

PL10-6-22



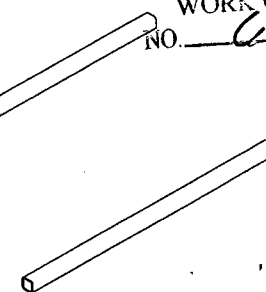
D4043-041 RIB ASSEMBLY



D4043-3 RIB



D4043-5 RIB



D4043-7 RIB



D4043-9 BUSHING

RELEASED
R 2010-02-16
MD

| | | | |
|------------|--------------------|---|--------------|
| A | NEW ISSUE | RF | 10.01.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D4043 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | RIB ASSEMBLY | NTS |
| DATE | 10.01.29 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

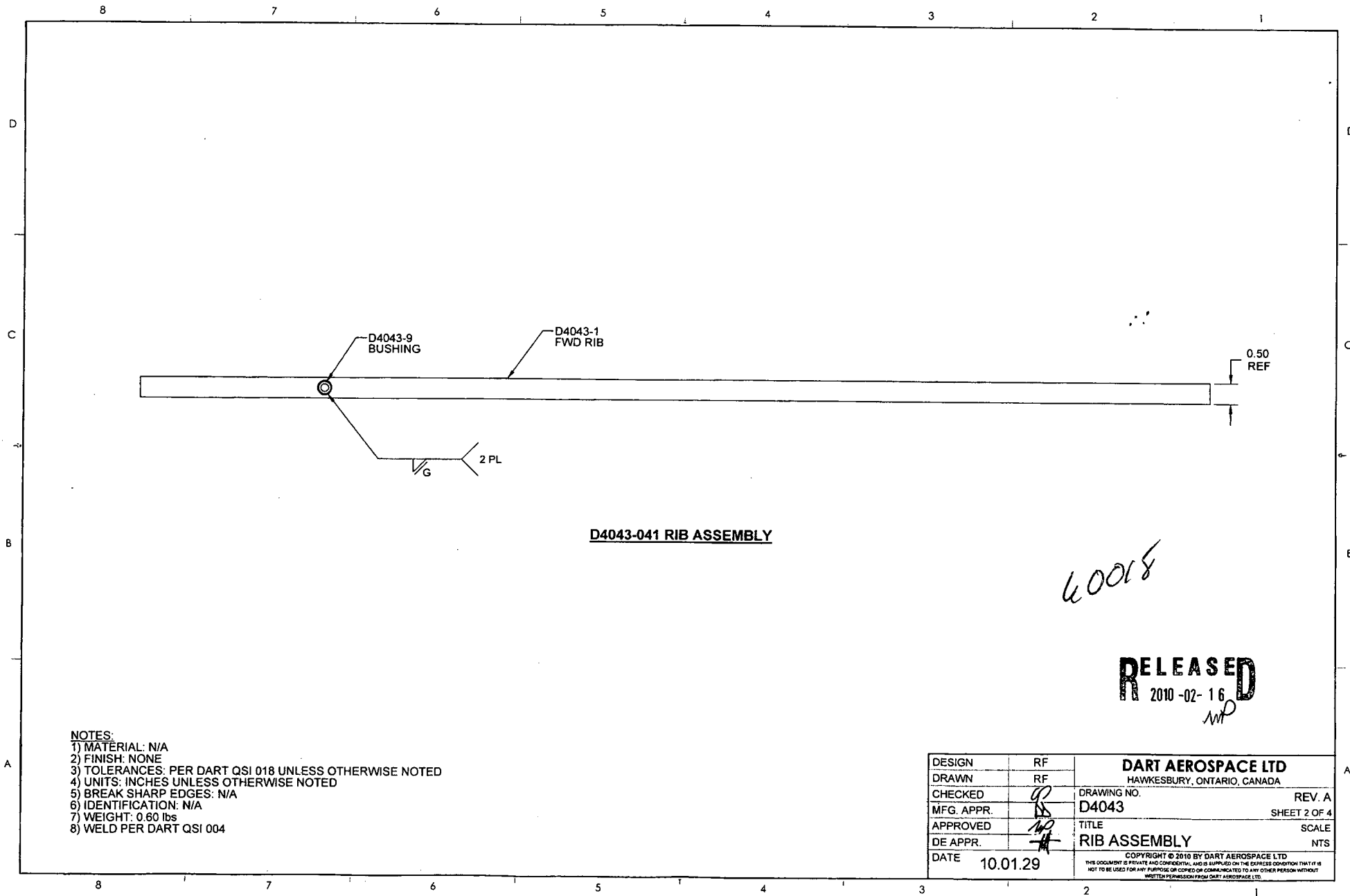
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NOTE: Date & initial all entries



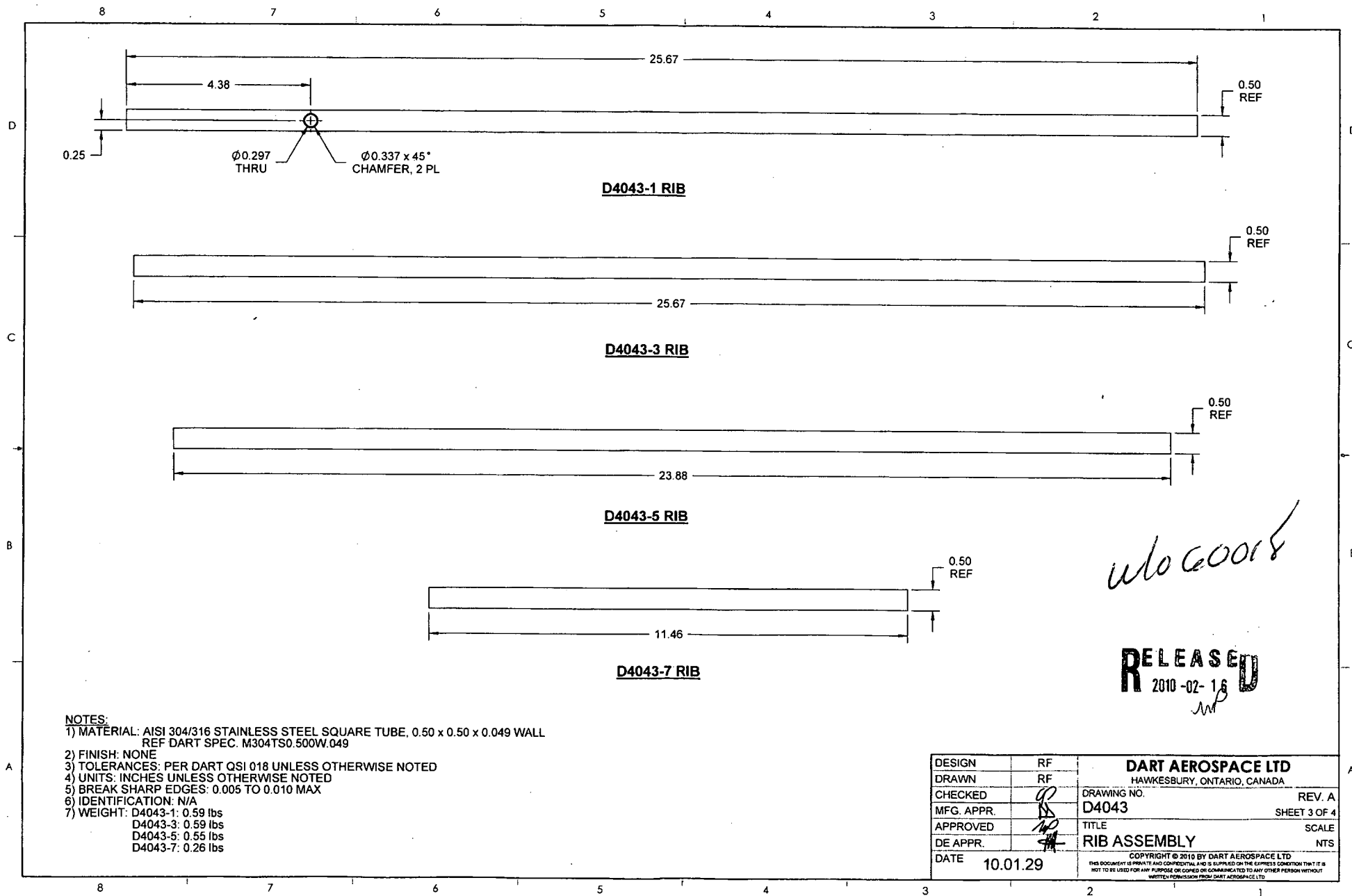
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NOTE: Date & initial all entries



WLO 60018

RELEASED
2010-02-16

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D4043-1: 0.59 lbs
D4043-3: 0.59 lbs
D4043-5: 0.55 lbs
D4043-7: 0.26 lbs

| | | | |
|------------|--------------------|---|--------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4043 | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 4 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | RIB ASSEMBLY | NTS |
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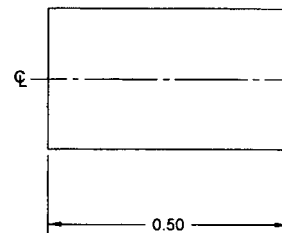
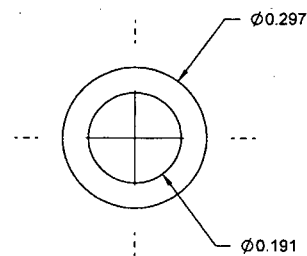
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| | | | | | | | | |

NOTE: Date & initial all entries



D4043-9 BUSHING

wlo 60018

RELEASED
2010-02-16
W

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.006 lbs

| | | | |
|------------|-----------|---|--------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>RF</i> | DRAWING NO. D4043 | REV. A |
| MFG. APPR. | <i>RF</i> | SHEET 4 OF 4 | |
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